Quality Control

June-03-13 9:2	0:54 AM			"1()2	75/4°						Page
Item ID: Revision ID: Item Name:	D2236 Lid Rib			Accept	*N900	<b>040</b>	100	<b>)</b> * ፡	Setup Star Stop	1/1	S1* S2*
Start Date: Required Date: Reference:	6/03/13 : 6/10/13	Start Qty: 6.00 Req'd Qty: 6.00	* <del>6</del> *6	* (2x)	Cust Item I Customer:	D:					
Approvals:	Process Pla	in: MUS	Date: 13~0(2	5-03 Tooling:	Da	nte:	_	l	Run Star	1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ite:			Stop	' *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			· ·				9		- Jump
D2236	С				•						
*100		Large Fab		0.00				20	N	13-6	
Large Fab Large Fab		Memo 1- Pick D310	66-3 and cut use DT	0.00 8303			(		. <u> </u>	<u>·</u>	?
		2- Remove i	dentification markin	gs on tube							
		3- Deburr							,		
*110 *11 <b>0</b> *		QC6- Inspect dimensions	to drawing	0.00 DA	\$ 13.6.4			ີ ~ົ√	÷		
QC		Memo		0.00	<b>∽</b>			<u>~ X</u>			

DQA:			Date:		,	_							****	TO AC		
						WORK ORDER NO	N-C	ONFO	RMANCE / UPDATE			_		AEROSPACE		
QA Closed:		<u> </u>	Date:					•		W	ork Order u	odate only				
Work Ord	o.r.					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Ord	ет.					Rework	٦		Skid-tube Crosstu	ubal	Water Jet			Engineering		
Part I	۷o.					Scrap	-		Machining Small	<b>—</b>	Pro	d. Eng. Coor.	┥╏	Quality		
,						Use-as-is	1		noforming Finish		-1	re/Packaging	_	Other		
NCR I	No.					Suspected Unapproved			Large Fab Compos			Supplier	7			
											_	-				
Root					Desc	ription of work order update	- 1	Initial	Action		Sign &					
Cause	,	Date	Step	Qty	ļ	or non-conformance	CI	hief Eng	Description		Date	Verification		QC Inspector		
Design	Н															
Doc/Data	Щ		1													
Equip/Tooling	Ш										į.					
Handling/Pre	Ш				}									•		
Material	Н															
Operator	Н															
Offset/Setup	H				<u> </u>											
Process	Н															
Supplier	$\vdash\vdash$															
Training	Н															
Transport	$\vdash$													•		
Unapproved			L					LUTCA	I TEGORY		<u> </u>			<del></del>		
Landi	na G	ear .				General	FA	OLI CA	IEGURT	· · · · · ·						
Lanui		Bending				Bend	Г	Teolio/E	Program	Г	Outside Dim	ansions [	$\neg$	essure/Forced		
٠	H	Centre No	nt Concen	ntric	-	BOM/Route	$\vdash$	Grain	TOGIAIN	<u> </u>	Over/Under	<b> </b>	_	t-up		
		Cracks	or concern	10110		Broken/Damage/Defect	$\vdash$	Hardwa	uro.	-	Part Incorre	<b>⊢</b>		mperature/Cure		
	Н	Crimp/Kir	nk/Rinnle	/Wave	-	Burrs	$\vdash$	-	ion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	<b>⊢</b>	-	•		
	H	Cuffs	,, pr.c,	, wave	-	Contamination	$\vdash$	<b>-</b> 1 '	tions Incomplete/Unclear	$\vdash$	Part Moved	331118	— 1	rong Stock Pulled		
	$\vdash$	Crushing			<u> </u>	Countersink	$\vdash$	-	gned/off center	-	Positioned V	Vrong L		ong stock i uncu		
	$\vdash$	Heat Trea	ıt			Cut Too Short		Mislabe		<u> </u>	Power Loss/		$\neg_{\circ}$	her		
·	-	Inspection		Tube		Drawing	$\vdash$	Misread			J. 544Ci 1033/			1101		
	-	Marks/Ch		-		Drill Holes		Off-set	-							
	-	Turning S				Finish		-{	Calibration							
	$\overline{}$	Wave/Tw		e	<u> </u>	Fit/Function		4	Sequence							

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June-03-13 9:20:54 AM

## \*102574\*

Page 2

T. 175	2000			•								
Item ID:	D2236			Accept	*N900	040	100	*	Setup S	start	*NI	<b>C1</b> *
Revision ID:						· · · · · ·		•		~.	I VI	. 7 1
Item Name:	Lid Rib								5	Stop	*N:	S2*
Start Date:	6/03/13	Start Qty: 6.00	*6*	, i hi o	Cust Item 1	D:						1
Required Date	e: 6/10/13	<b>Req'd Qty:</b> 6.00	*6*		Customer:							
Reference:			<b>(</b> )	•								
Approvals:	Process P	lan:	Date:	Tooling: _	D	ate:	_	]		Start	*N	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:			S	Stop	*N	R2*
Sequence ID/		Operation		Set Up/	Tool ID	Tool #	Plan	Accept	Reject	t F	Reject	Insp.
Work Center	ID	Description		Run Hours			Code	Qty	Qty	N	Number	Stamp
120		Identity as per dwg & S	tock Location: WA	0.00 ( <b>SAS</b>	13.6.4		7	3	`			
*120* Packaging				0.00	12.6			~x	/			
Packaging		Memo		0.00								i
									,			e .
												•
130		QC21- Final Inspection	- Work Order Release	0.00								
*130*								,	MUS	\	2-01-	-05
QC		Memo		0.00			-	/	vico	— <u>`</u>	3 00	09
Quality Control												

dB des

DQA:		- Date:			- WORK CORED NON CONSORTANCE (WORK)										
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE	w	ork Order up	odate only	AEROSPACE			
					DISPOSITION			AGAINST							
Work Orde	r:					1				7	·	<del></del> -			
D 4 M					Rework			Skid-tube Crosstube		_	Water Jet	Engineering			
Part N					Scrap			Machining Small Fab		<b>-</b>	d. Eng. Coor.	Quality			
NCR N	lo.				Use-as-is Suspected Unapproved		Inerr	noforming Finishing Large Fab Composite	_	Kec/Stol	re/Packaging	Other			
NCK IV					Suspected Offapproved	]		Large Fab Composite		j	Supplier				
Root				Desc	ription of work order update		Initial	Action		Sign &	7				
Cause	Date	1 1 1			or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector			
Design															
Doc/Data		ł		1											
Equip/Tooling				}						•		·			
Handling/Pre	_														
Material		ļ	,	-		ļ				:					
Operator	_			-											
Offset/Setup								1				·			
Process															
Supplier															
Training															
Transport															
Unapproved	· .	<u> </u>	<u> </u>					·							
	<del></del>				·	FAI	ULT CAT	TEGORY				· · · · · · · · · · · · · · · · · · ·			
Landin	g Gear				General					•					
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced			
.	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up			
Ļ	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct	Temperature/Cure			
-	Crimp/Kir	nk/Ripple	/Wave	_	Burrs	Ŀ	Inspecti	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld			
	Cuffs				Contamination	<u> </u>	4	tions Incomplete/Unclear		Part Moved	<u></u>	Wrong Stock Pulled			
<u> </u>	Crushing			<del> </del>	Countersink		•	gned/off center		Positioned V	· -	<b>-</b>			
-	Heat Trea				Cut Too Short	$\overline{}$	Mislabe			Power Loss/	Surge	Öther			
	Inspectio		Tube		Drawing	$\vdash$	Misread		٠						
	Marks/Ch			<u> </u>	Drill Holes	$\vdash$	Off-set	*							
	Turning S			<u> </u>	Finish	Out of Calibration									
	Wave/Tw	ist in Tub	10		Fit/Function		Out of s	Coguenco							

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## **Picklist Print**

June-03-13 9:20:58 AM

Work Order ID: 102574

Parent Item: D2

D2236

Parent Item Name: Lid Rib

\*102574\*
\*D2236\*

**Start Date:** 6/03/13

Required Date: 6/10/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A 12.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3		Manufactured	No			100	Each	11.0387	0.25	1.5			!
*D3166-3*									**		13	-6-4	

Location	Loc Oty	Loc Code	
WA	0.494736		
94157	0.494736		
WA004	10.1052		
81578	0.1052		
98074	10		(0,5)
WA007	0.4388		
77 <u>2</u> 94	0.4388		·

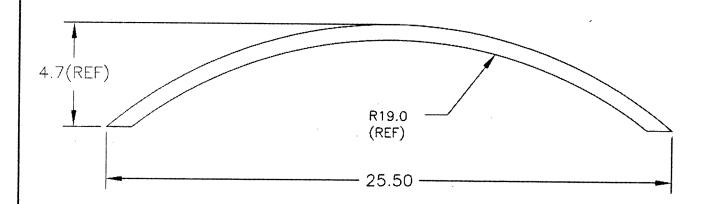
DQA:			Date:				<b>™</b> ⊃∧ <b>D</b> T								
						WORK ORDER NON	-C(	ONFO	RMANCE / U						AEROSPACE
QA Closed:			Date:		-					\ <u>\</u>	Work Or	der u	pdate only	<u> </u>	
Work Orde	er:					DISPOSITION									
	_					Rework	]		Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.		-			Scrap			Machining	_	Prod. Eng. Coor.			Quality	
-	_					Use-as-is			noforming	Small Fab Finishing	⊢ Re	Rec/Store/Packaging			Other
NCR N	١o.					Suspected Unapproved	4 1		Large Fab	Composite			Supplier	-	
							•				<b>—</b>			-	
Root					Desc	cription of work order update		Initial	Act	ion	Sign	า &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption	Da	te	Verificatio	n_	QC Inspector
Design															
Doc/Data														İ	
Equip/Tooling														!	
Handling/Pre															
Material															
Operator	_									- [					
Offset/Setup	_														
Process	_						1								
Supplier				:											
Training	$\dashv$														
Transport				1									[		
Unapproved									[				<u> </u>		
Landir							FA	ULI CA	TEGORY					—	
Lanuii		ar ending				<b>General</b> Bend		ا دانه ا	rogram	Г	٦	l. 6'		_	la <i>1</i> 5 1
}		_	ot Concen	tric	}-	BOM/Route	$\vdash$	Grain	rogram	-	<del></del>		iensions	-	Pressure/Forced
<b> </b>		racks	or concer	itite		Broken/Damage/Defect	-	Hardwa	ro	-	Part Ir		tolerance		Set-up
			nk/Ripple,	/\ <i>M</i> >ve	-	Burrs	$\vdash$	ł	on Incomplete/Un	auglified	Part Lo			<del></del>	Temperature/Cure
Ì			путпрріс,	, wave	-	Contamination		1	ions Incomplete/U	· -	Part N		issing	$\vdash$	Weld
	_	Cuffs Crushing				Countersink		1	ned/off center	-	Position		Mrong	ш	Wrong Stock Pulled
}	Heat Treat					Cut Too Short		Mislabe		-	Power		-		Other
Ì	Inspection Strip in Tube			Tube	-	Drawing		Misread		L	' ower	LU33/	Juige	Ш	- Curei
Ì	—-	larks/Ch	٠.			Drill Holes	$\vdash$	Off-set	•				<del></del>	—	
ļ	_		equence			Finish	$\vdash$	1	Calibration					<del></del>	
·	Wave/Twist in Tube					Fit/Function		1	equence				<u></u>		

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L	BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA										
CHE	CKED	APPROVED	1	REV. C									
	7/1	<del></del>	D2236 SHEET 1	OF 1									
DATE			TITLE	SCALE									
05.	06.07		LID RIB	1:4									
Α		94.05.30	NEW ISSUE										
B		94.12.16	LID										
С		05.06.07	UPDATE NOTES, CHANGE RADIUS TO 1	9.0									

RELEASED 05.08.19



D2236

## D2236 LID RIB

- MAKE FROM D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

DQA:			Date:													
						<b>WORK ORDER NON</b>	-CO	ONFO	RMANCE / U	IPDATE				AFROSPACE		
QA Closed:			Date:								W	ork Order up	odate only			
Work Ord	er:					DISPOSITION				/PROCESS						
Part I	No. <sub>.</sub>				·	Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			4 '	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root				,	Desc	ription of work order update	1	nitial	Ac	tion		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved																
							FAL	ULT CA	regory							
Landi	ing Gear  Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off_center Mislabeled Misread			Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
	Turning Sequence Wave/Twist in Tube				-	Finish Fit/Function	$\vdash$	1	Calibration Sequence							

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